Work Order ID 48528	Work	Orde	r ID	48528
---------------------	------	------	------	-------

E1

July 1, 2009 7:37:37 AM

Page 1

Item ID:

D2199-25

Accept

Setup Start

Stop



Revision ID:

Start Date:

Item Name: Strut Details

Required Date: 08/03/2009

07/15/2009

Start Qty: 4.00

Req'd Qty: 4.00



Cust Item ID:

Customer:

Reference:

Approvals:

QC: _____

Date:

Date:

Tooling: SPC (Y/N):

Date:

Date:

Run Start

Stop

SB 09/07/02

Sequence ID/ **Work Center ID**

Operation **Description** Set Up/ **Run Hours** Draw Number

Draw Rev.

Plan Accept Qty Code

Reject Qty

Reject Number

Insp. Stamp

Draw Nbr

Revision Nbr

D2199 Rev E1

Brake NC

Memo

0.00

0.00

Brake NC

Punch per Dwg D2199 and Spec Contol Dwg D2638

110

Small Fab

Small Fab

Memo

Deburr

0.00

0.00

m.h 04/07/07

120

QC

QC5- Inspect part completeness to step on W/O

0.00

Sorbolo @



Quality Control

Memo

E1

Page 2

Item ID:

D2199-25

Accept

Setup Start



Revision ID:

Start Date:

Item Name: Strut Details

Required Date: 08/03/2009

July 1, 2009 7:37:37 AM

07/15/2009

Start Qty: 4.00

Req'd Qty: 4.00



Date:

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Start Run



QC:

SPC (Y/N):

Date:

Stop

Sequence ID/ **Work Center ID**

Description White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

Operation

Set Up/ **Run Hours** Draw Number Draw Rev.

Plan Accept Qty Code

Reject Qty

Reject Insp. Number Stamp

130

Powdercoat

Powder Coating

Memo

POWDER COAT: Start Time: 3100 pv

Oven Temperature: 400 1= Finish Time: 3: 3000

0.00

0.00

M111472 09-07-07 (X4

140

QC

Quality Control

QC3-Inspect Part Finish

0.00

09-07-8

Memo

0.00

150

Packaging Packaging

Identify as per dwg & Stock Location: 1



0.00

Memo

0.00

Work Order ID 48528

E1

July 1, 2009 7:37:37 AM

Page 3

Item ID:

D2199-25

Accept

Setup Start

Revision ID:

Start Date:

Item Name: Strut Details

Required Date: 08/03/2009

07/15/2009 Start Qty: 4.00

Req'd Qty: 4.00

Cust Item ID:

Customer:

Reference:

Process Plan:

Date:

Tooling:

Date:

Run

Start

Stop

Approvals:

QC:

Date:

SPC (Y/N):

Date: _____

Stop

Sequence ID/

Work Center ID

Operation Description

QC21- Final Inspection - Work Order Release

Set Up/ **Run Hours** Draw Number

Draw Plan Rev. Code

Accept Reject Qty Qty

Reject

Insp. Number Stamp

160

QC

Memo

0.00

0.00

09607/09 Aff

Quality Control

Picklist Print

July 1, 2009 7:37:36 AM

Work Order ID: 48528

Parent Item:

D2199-25RevE1

Parent Item Name: Strut Details

Comments:



111619

Start Date: 07/15/2009

Required Date: 08/03/2009

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304TR0.750W.049		Purchased	No			100	f	176.8673	7.0876	, , , , , , , ,		1.1
	13 1051 100 11 11 12 15 16 17 18 18 18 18 18 18 18								IIII M	(10017	S551	(07(07

304 RD Tube .750 x .049W

Warehouse	Loc Qty	Loc Code	
Location			·
Main Warehouse			
MAT	176.86		
107518	7.27		
108498	0		
109314	8.5		
110113	0.73		
110271	0.03		
111096	9		
111457	11.43		

139.9

Øate: User:

Friday, 12/06/2009 9:53:34 AM

Julie Dawson

Process Sheet

Customer

: CU-DAR001 Dart Helicopters Services

Job Number : 48528 : 10220

Estimate Number

P.O. Number

: 12/06/2009 This Issue

Prsht Rev. : NC

First Issue Previous Run

: // : 43597

Type

S.O. No. :

: SMALL /MED FAB

Part Number

Due Date

Drawing Name

: D219925

: STRUT

Drawing Number

D2199 / D2638 : N/A

Project Number

: E1/ A

Drawing Revision

Material

: 22/06/2009

Qty:

Each 4 Um:

Checked & Approved By

Comment

Written By

: Est:D 02.06.10

Rmv polish & add finish NG/RF

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0 M304TR0750W049

304 RD Tube .750 x .049W



Comment: Qty.: 1.7675 f(s)/Unit Total: 7.0699 f(s)

Material: 304/316 SS tubing 0.750" Dia. x 0.049" wall

(M304TR0750W049)

Batch No:

2.0

BRAKE NC

NC BRAKE



Comment: BRAKE NC

Punch per Dwg D2199 and Spec Control Dwg D2638

3.0

SMALL & MEDIUM FAB RESOURCE 1





Deburr

QC5

INSPECT WORK TO CURRENT STE



4.0

Comment: INSPECT WORK TO CURRENT STEP

POWDER COATING



5.0

POWDER COATING



M111472



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE: 4009

FINISH TIME:

08-07-07



Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES											
DATE	STEP	PRO		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector					
111													
Part No	:	PAR #:	Fault Categ	ory:	NCF	R: Yes	No DQA :		_ Date: _				
Resolution:			Disposition	QA:	QA: N/C Closed: Date:								
NCR:			WORK ORDE	R NON-CONFORM	IANCE	(NCR)						
DATE	STEP	Description of NC	Corrective Action Section			0: 0	Verificat	tion	Approval	Approval			
		Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Section	С	Chief Eng	QC Inspector			
						- 198							
					ļ								

NOTE: Date & initial all entries

Date: Friday, 12/06/2009 9:53:34 AM User: Julie Dawson **Process Sheet Drawing Name: STRUT** Customer: CU-DAR001 Dart Helicopters Services Job Number: 48528 Part Number: D219925 Job Number: Seq. #: Machine Or Operation: Description: INSPECT POWDER COAT/CHEMICAL CONVERSION QC3 6.0 Comment; INSPECT POWDER COAT PACKAGING 1 PACKAGING RESOURCE #1 7.0 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: QC21 FINAL INSPECTION/W/O RELEASE Comment: FINAL INSPECTION/W/O RELEASE Job Completion/

Dart Aerospace	Ltd
-----------------------	-----

W/O:			WC	RK ORDER CHANG	GES			· · · · · · · · · · · · · · · · · · ·				
DATE	STEP	PRO	В	/	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
									1 Tod Ivigi			
Part No		PAR #:	Fault Category: NCR: Yes N					No DQA: Date:				
	R	esolution:	Disposition	n:	QA: N/	C Clo	sed:		Date: _			
NCR:			WORK ORDI	R NON-CONFORM	ANCE (N	ICR)						
DATE	STED	STEP Description of NC Section A	Corrective Action Section B			Verificatio			Approval	Approval		
	0.2.		Initial Action Description Chief Eng Chief Eng			Sign & Date		on C	Chief Eng	QC Inspector		
					į							
					I							
					3							
	1	į '					1		l	I		

NOTE: Date & initial all entries

98.04.28

STRUT DETAILS

1993

NEW ISSUE

-11,

13

AND

15

ADDED ADDED

AND

19

ADDED

-21 -17 $\boldsymbol{\varpi}$ >

02.03.22

ADD FINISH

98.04.28

ADDED -23 AND ADDED TEMPLATE REDRAWN IN CAD

<u>ا</u> ج

-25 PER & SPEC (

CTR/ TSR

A565M DWG

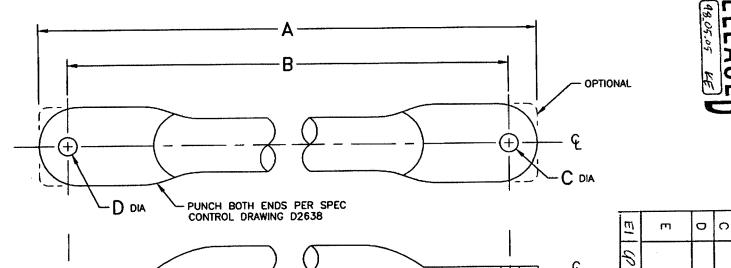


DRAWING NO. D2199

SHEET

SCALE 유

NTS



	Α	В	С	D.	
D2199-1	18.30	17.50	0.257	0.257	
D2199-3	5.80	5.00	0.257	0.257	
D2199-5	22.64	21.84	0.257	0.316]
D2199-7	14.74	13.94	0.257	0.257	
D2199-9	16.52	15.72	0.257	0.257	
D2199-11	23.60	22.80	0.257	0.316	B
D2199-13	15.96	15.16	0.257	0.257] (
D2199-15	17.57	16.77	0.257	0.257] (0)
D2199-17	28.05	27.25	0.257	0.316]
D2199-19	18.90	18.10	0.257	0.257]
D2199-21	10.80	10.00	0.257	0.257]
D2199-23	26.18	25.38	0.257	0.316], (2)
02199-25	19.93	19.13	0.257	0.257	
D2199-27	27.34	26.54	0.257	0.316	3 # 00.10.13 ipoo.10.13
02199-29	21.11	20.31	0.257	0.257	1) 70 - 1013

- 1. MAKE PER TEMPLATE DT2199-XX WHERE XX IS THE RESPECTIVE DASH NUMBER 2. MATERIAL: AISI 304/316 STAINLESS STEEL TUBE \$0.750 x 0.049 WALL 3. FINISH: POWDER COAT WHITE (4.3.5.Z) PER DART QSI COS 4.3/EI

Copyright 1993 by DART AEROSPACE LTD

SUBJECT TO AMENDMENT

UNCONTROLLED COPY

ENGINEERING

RETURN TO

SHOP COPY

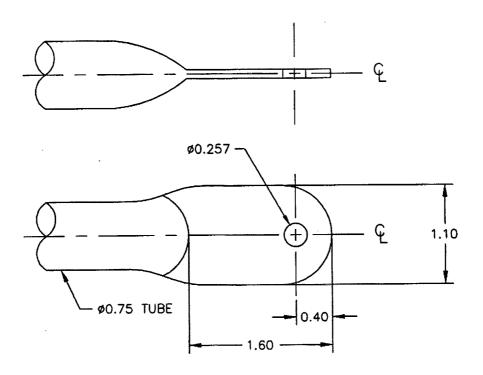




	DESIGN	DRAWN BY	DART AEROSPACE LTD	
	KE.	JAC-	HAWKESBURY, ONTARIO, CANADA	004
	CHECKED	APPROVED	DRAWING NO.	REV. A
	MIN	17	D2638 SHEET	
;	DATE		TITLE	SCALE
	98.04.28		PUNCH DT8117 SPEC CONTROL	1:1
	Α	98.04.28	NEW ISSUE	



SPECIFICATION CONTROL DRAWING FOR PUNCH DT8117



SHOP COPY RETURN TO FNGINEERING UNCONTROLLED COPY

Copyright 1998 by DART AEROSPACE LTD

WITHOUT NOTICE
WORK ORDER